

Work Order ID 120909

June-18-14 11:20:20 AM

120909

Page 1

Item ID: D4935-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: EAPS Bracket
 Start Date: 6/13/14 Start Qty: 60.00 ***60*** 86 Cust Item ID:
 Required Date: 6/13/14 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-06-18 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4935	B								
100	FLOW WATER JET	0.00						DAS 23 9-89	
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u>								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00						DAS 23 9-89	
110									
QC	Memo	0.00							
Quality Control									

60
PTO →
mm 14/06/19
mm 14/06/19

DQA:

Date: 14/07/30



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/7/30

Work Order update only ☐

Work Order: <u>120909</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4935-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-4089</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other
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Item ID: D4935-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: EAPS Bracket

Start Date: 6/13/14 Start Qty: 60.00

60

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

27

9/89

120

0.00

4/7/19

60

QC

Memo

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

DAS
30
9-89

60

4/6/09/09

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

SIS
4/7/19

60

C. Chen

Quality Control

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 Required Date: 6/13/14 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				60	7/17-7		
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							DAS 41 9-89
160									
QC	Memo	0.00				60	0	0	14-7-28
Quality Control									
170	Gloss Black (Alum) (Ref:QSI005 4.3.5.13)	0.00							DAS 41 9-89
170									
Powdercoat	Memo	0.00				60	0	0	14-7-28
Powder Coating	START TIME: 335 OVEN TEMPERATURE: 320 FINISH TIME: 405								

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC3- Inspect Part Finish	0.00	DAS	16		60			
180		14/07/29	9-89						
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: <u>5T127</u>	0.00				60X			
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

14/7/29 JH
 14-7-29

Picklist Print

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Work Order ID: 120909

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Parent Item: D4935-1

D4935-1

Parent Item Name: EAPS Bracket

Start Date: 6/13/14

Required Date: 6/13/14

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A 13.10.02 NEW ISSE DD VERF:JLM IPP
REV:B 14.06.18 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No			sf	380.7880		<u>1</u>			DAS 23 9-09
M6061T6S 063									**				14-07-8.

6061-T6 .063 Sheet

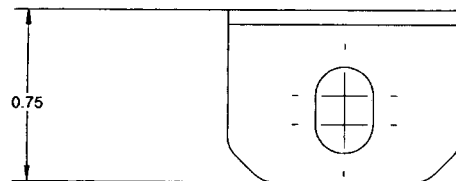
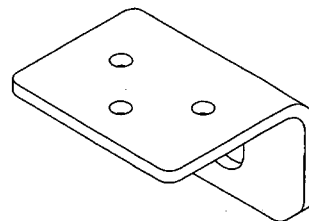
Location	Loc Qty	Loc Code
MAT021	380.788	
M124446	3.7	
M126075	4.5	
M127006	9	
M127420	117.12	
M128054	63.468	
M128941	183	

m128941

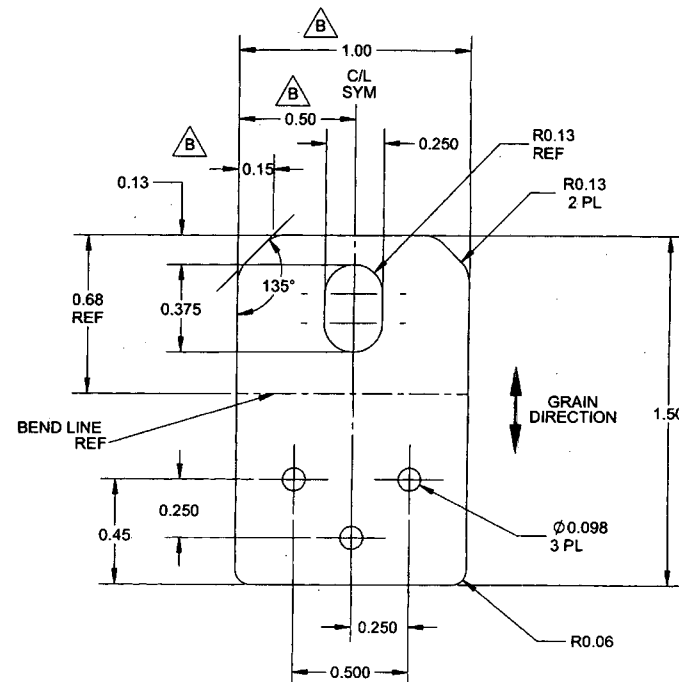
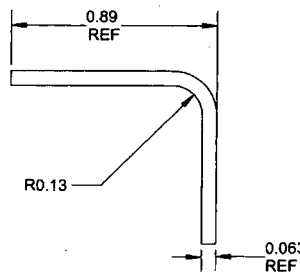
128941

128941

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120909 MLJ
14-06-18



D4935-1 EAPS MOUNTING BRACKET



D4935-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: D4935-1: MAKE FROM D4935-1F
D4935-1F: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209, REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 LBS

RELEASED
2014-06-16

B	ADD 0.15 X 45° CHAMFER, 2 PL, 1.00 WAS 1.09	DB	14.01.16
A	NEW ISSUE	DB	13.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS		
DATE	14.01.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4935	REV. B SHEET 1 OF 1
TITLE EAPS MOUNTING BRACKET	SCALE NTS
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